CHAPTER 8: DRUM SECTION

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3. Adjustment

1. Squeegee Gap

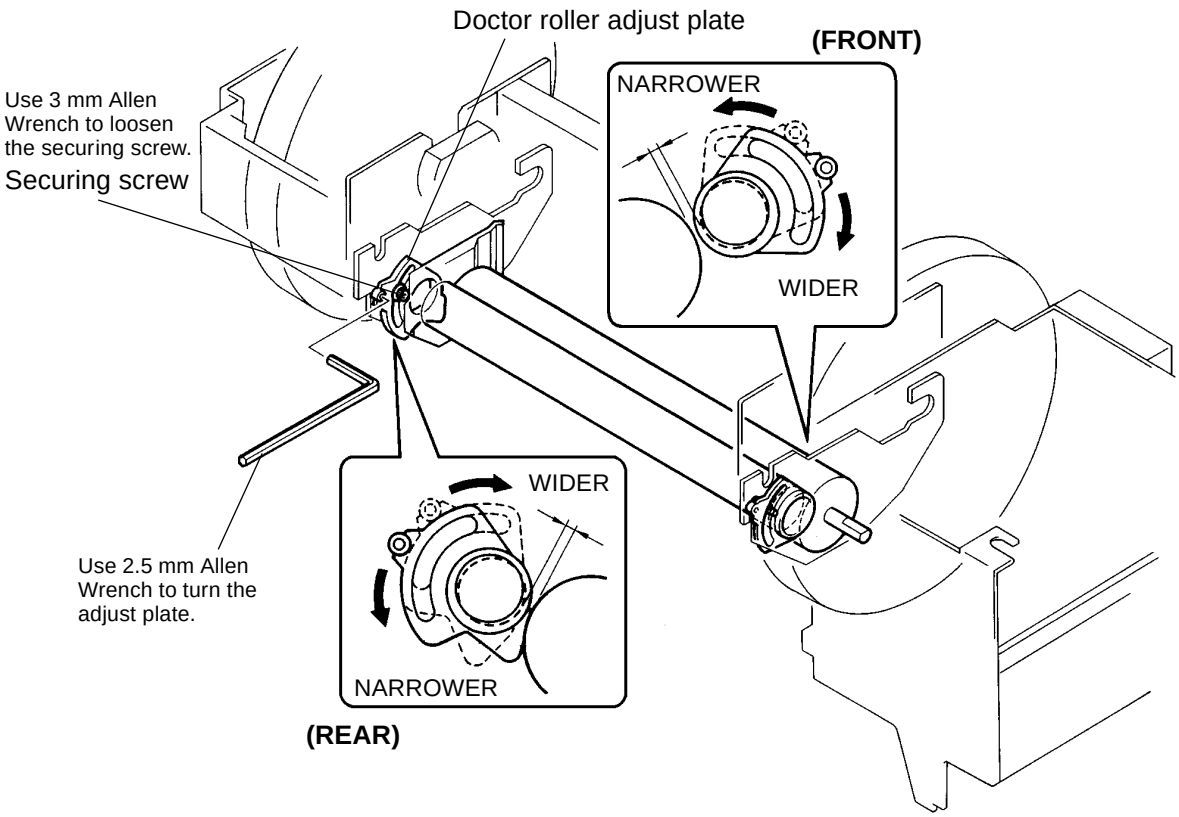
1. Make a confidential master on the Drum.
2. Remove the Drum from the machine.
3. Remove the Screen. (page 8-9)
4. Remove the Drum body. (page 8-10)
5. Clean out the ink from the Squeegee unit.
6. Using feeler gauge, measure the gap between the Squeegee roller and Doctor roller.
   The gap should be 0.08 mm ± 0.02 mm.
   If not, the gap should be adjusted.
7. To adjust, loosen the securing screw of the Doctor roller adjust plate located at both ends of the Squeegee unit.
8. Move the adjust plate by inserting a rod, such as 2.5mm Allen wrench, in the hole on the plate to change the Squeegee gap.
9. Tighten the securing screw of the two Doctor roller adjust plates after the adjustment is done.

Caution in Adjustment

- The Squeegee gap between the Squeegee roller and Doctor roller should be equal throughout the length of the two rollers.

Results of Incorrect Adjustment

- **If the gap is too big:**
  Too much gap will allow excess amount of ink to get on the inner surface of the Drum and results in ink leakage from the Drum.
- **If the gap is too small:**
  Not enough ink transfers on the inner surface of the Drum and the prints may come out with uneven print density.



2. Squeegee Pressure Balance

Make a master and print with Test Chart No.8 and check the print density on the left and right of the prints. If the print density is uneven, do the following adjustment.

(FRONT)

1) Remove the Drum from the machine, and Ink pack from the Drum.
2) Remove Drum cover.
3) Remove Ink pack holder ass'y. (page 8-20)
4) Remove Ink pump unit. (page 8-18)
5) Loosen two mounting screws of the Squeegee frame through the holes on the Drum support F.
6) Use a screw driver to turn the Eccentric boss to adjust the Squeegee pressure.
   The gap between the Squeegee roller and the Drum body should be between **0.5 to 1.0 mm**.
7) Tighten the two mounting screws of the Squeegee frame.

(REAR)

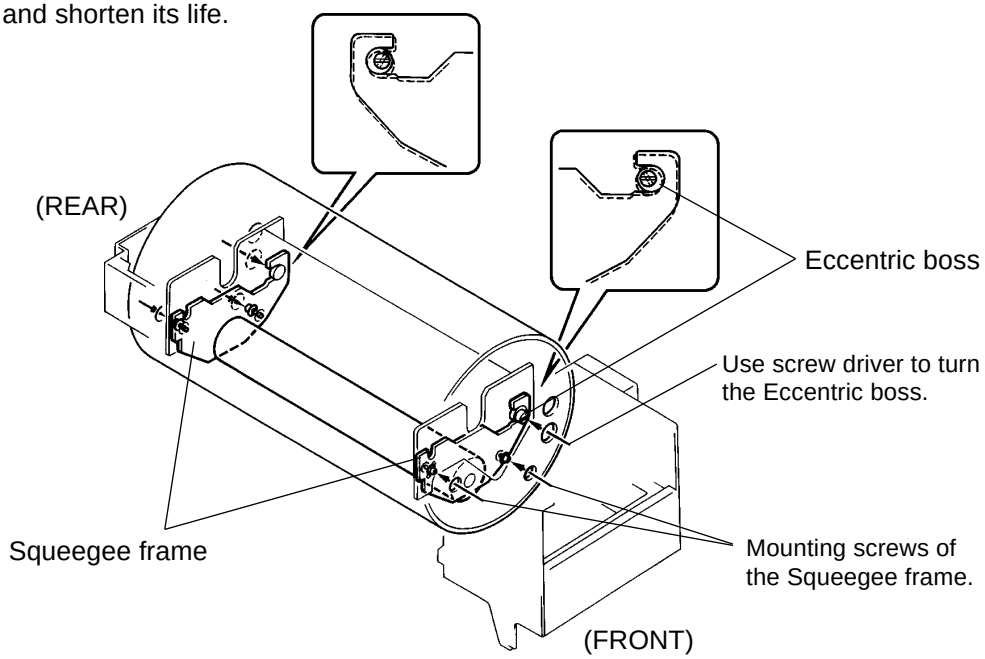
1) Remove the Drum from the machine.
2) Loosen two mounting screws of the Squeegee frame through the holes on the Drum support R.
3) Use a screw driver to turn the Eccentric boss to adjust the Squeegee pressure.
   The gap between the Squeegee roller and the Drum body should be between **0.5 to 1.0 mm**.
4) Tighten the two mounting screws of the Squeegee frame.

Checks after the Adjustment

- The gap between the Squeegee roller and the Drum body should equal between the front and rear.
- With a confidential master on the Drum, run the papers through the machine in quantity and check for any ink leakage from the Drum.
  If the ink starts to leak, the Squeegee pressure needs to be readjusted.

Results of Incorrect Adjustment

- **If the Squeegee pressure differs between the left and right:**
  The print density may become uneven between the left and right of the prints.
- **If the Squeegee pressure is too strong:**
  Excess amount of ink will get on the inner surface of the Drum and may result in ink leakage from the Drum.
- **If the Squeegee pressure is too weak:**
  The print density may become uneven or too light, and too much stress is applied on the Drum body and shorten its life.



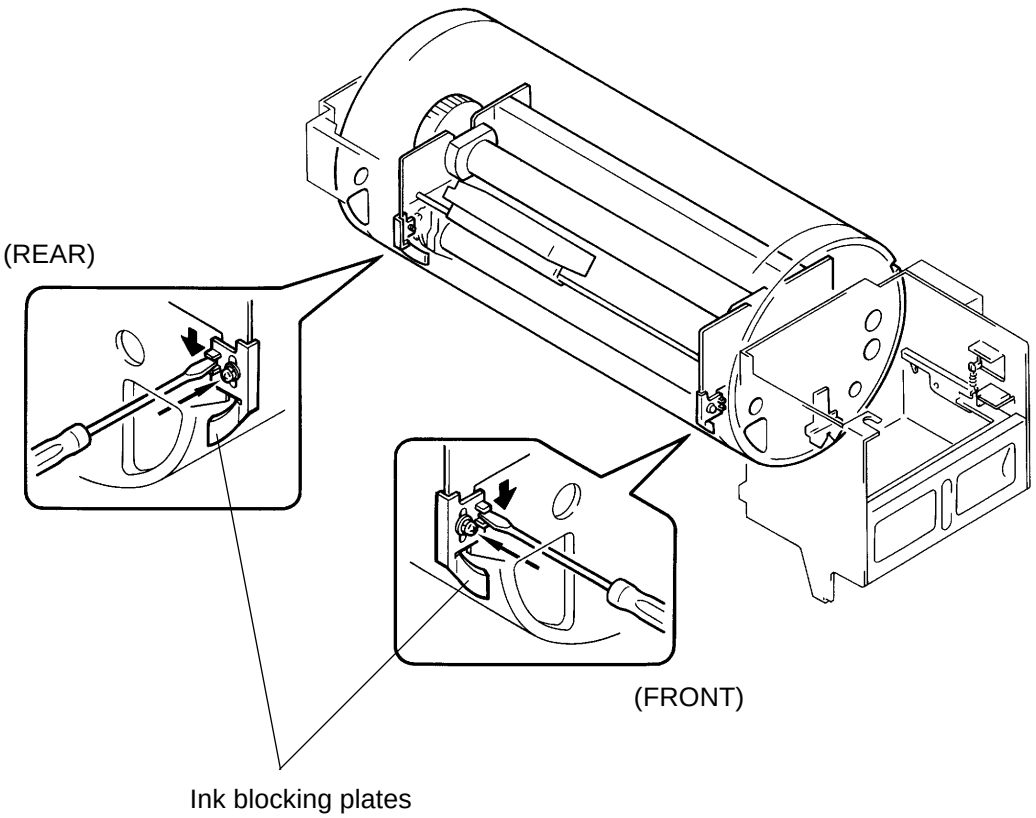
3. Ink Blocking Plate Position

(FRONT)

1) Remove the Drum from the machine, and Ink pack from the Drum.
2) Remove Drum cover.
3) Remove Ink pack holder ass'y. (page 8-20)
4) Remove Ink pump unit. (page 8-18)
5) Loosen mounting screw of the Ink blocking plate through the hole on the Drum support F.
6) Use a screw driver to push the Ink blocking plate against the Drum inner surface.
7) Tighten the mounting screw of the Ink blocking plate while pushing the Ink blocking plate against the Drum.

(REAR)

1) Remove the Drum from the machine.
2) Loosen the mounting screw of the Ink blocking plate through the hole on the Drum support R.
3) Use a screw driver to push the Ink blocking plate firmly against the Drum inner surface.
4) Tighten the mounting screw of the Ink blocking plate while pushing the Ink blocking plate against the Drum.

Results of Incorrect Adjustment

- If the Ink blocking plates are not flat against the Drum inner surface, the Ink will start leaking out of the Drum.